

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-002539**Date Inspected:** 21-May-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Chen Chih-Ming, An Qingxiang			CWI Present:	Yes	No	
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A

Bridge No: 34-0006**Component:** OBG side and bottom panels and tower skin p**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Steve Hall was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

OBG new assembly bay 2

QA noted that ZPMC has rejected 1 of 7 UT weld repairs on side panel SP-24A – SP-32A SEG-020A-002.

Other general observations include ZPMC personnel grinding side and bottom panels and weld bevel prep.

New Tower Bay 1

QA performed 10% Ultrasonic Testing (UT) verification of weld repairs on skin plate joint# SSD1-SA179D/E-19A. The results of the test appeared to be in compliance with the contract documents.

QA performed 10% verification Magnetic particle Testing (MT) on the following skin plate weld joints: SSD1-SA180C/E-7A and SSD1-SA179D/E-19A. The results of the test appeared to be in compliance with the contract documents.

QA noted that ZPMC qualified welding personnel have been SAW welding on the following skin plate joints: SSD1-SA18D/E-2, SSD1-SA18E/E-3A, SSD1-SA18D/E-3, SSD1-SA18D/E-5A, SSD1-SA18E/E-1, SSD1-SA18E/E-20.

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New Tower Bay 3

QA performed 10% verification Magnetic particle Testing (MT) on completed Partial Joint Penetration (PJP) U-rib to deck plate welds on deck panels DP-002-002 welds 1 thru 8, DP-008-001 welds 1 thru 6, DP-059-001 welds 1 thru 10 and DP-002-001 welds 1 thru 8. The results of the tests appeared to be in compliance with the contract documents.

Other general observations in the New Tower bays include ZPMC tack welding tower skin plates, weld bevel preparation, flame straightening, CNC parts cutting and grinding.



Summary of Conversations:

Only general conversations were held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Patrick Lowry (858)-344-2712, who represents the Office of Structural Materials for your project.

Inspected By:	Hall,Steven	Quality Assurance Inspector
Reviewed By:	Cuellar,Robert	QA Reviewer
